

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55882

February 3, 2010 1:53:58 PM



Page 2

Item ID: D4027-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Hose Clamp Assembly

Start Date: 2/03/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/10/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/31 *[Signature]*

C21018131

POSITIVE RECA-

EFFECTIVE 10-08-21

RELEASED *[Signature]*

INT: 100831

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 3, 2010 1:54:02 PM

Page 1

Work Order ID: 55882

Parent Item: D4027-041

Parent Item Name: Hose Clamp Assembly

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by:JLM



Start Date: 2/03/10

Required Date: 2/10/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN743-13		Purchased	No			100	Each	20.0000	2.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>BRACKET</p> </div> <div> <p>M 113706</p> </div> <div>  </div> </div>												

Warehouse Loc Qty Loc Code

Location



Main Warehouse

ST329

20

113706

20

D4027-1		Manufactured	No			100	Each	0.0000	2.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>Hose Clamp</p> </div> <div> <p>B 46077</p> </div> <div>  </div> </div>												

D4027-7		Manufactured	No			100	Each	0.0000	2.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>10.08.30</p> </div> <div> <p>B 55879</p> </div> <div>  </div> </div>												

Rubber Cushion												
MS21042L06		Purchased	No			100	Each	190.0000	2.0000			
<div style="display: flex; justify-content: space-between;"> <div>  </div> <div> <p>B 55888</p> </div> <div>  </div> </div>												

Nut												
-----	--	--	--	--	--	--	--	--	--	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

190

109167

2

110123

9

110731

14

111548

1

112433

64

112465

100

Sp 10/04/14 @

Sp 10/04/14 @

Sp 10/04/14 @

Sp 10/08/30 @

Sp 10/04/14 @

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

February 3, 2010 1:54:02 PM

Work Order ID: 55882



Parent Item: D4027-041



Parent Item Name: Hose Clamp Assembly

Start Date: 2/03/10

Required Date: 2/10/10

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by:JLM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24693-S28 Screw		Purchased	No			100	Each	173.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	173	
11334	96	
4824	29	
8170	48	

2

So 10/04/14 ②

NAS1149DN632J Washer		Purchased	No			100	Each	90.0000	2.0000			
-----------------------------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	90	
112794	90	

2

So 10/04/14 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

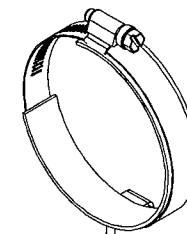
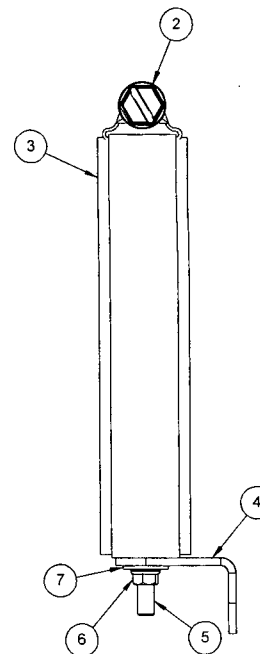
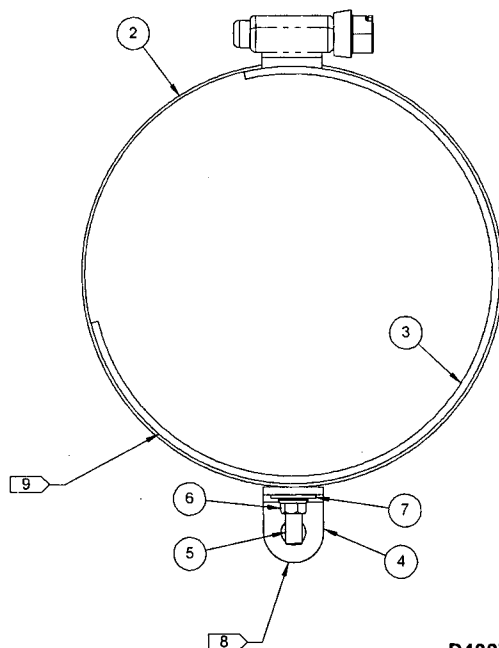
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-041	HOSE CLAMP ASSEMBLY	JCA-M47-2-20
2	1	D4027-1	HOSE CLAMP	
3	1	D4027-5	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT ANGLE	
5	1	MS24693S28	SCREW ✓	
6	1	MS21042L06	NUT ✓	
7	1	NAS1149DN632J	WASHER ✓	



SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55882
2010-2-03

D4027-041 HOSE CLAMP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-5 RUBBER CUSHION TO D4027-1 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

PRELIMINARY ISSUE

10.01.20

PA2	NEW ISSUE		10.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4027
TITLE CLAMP
REV. PA2
SHEET 1 OF 7
SCALE NTS

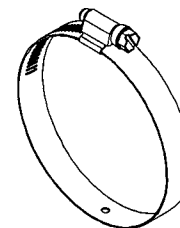
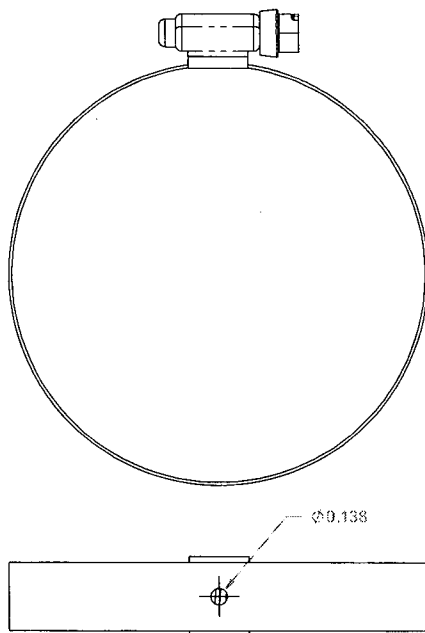
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DART AEROSPACE
PART NUMBER

D4027-1

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-20



D4027-1 HOSE CLAMP

NOTES:

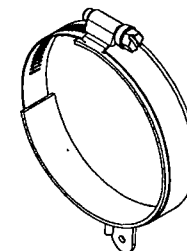
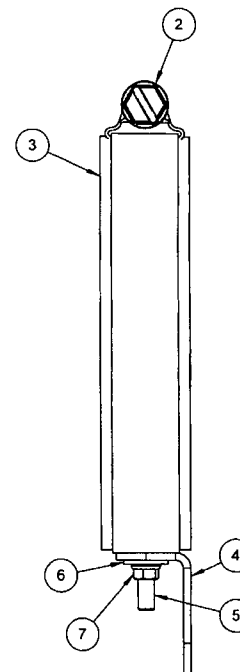
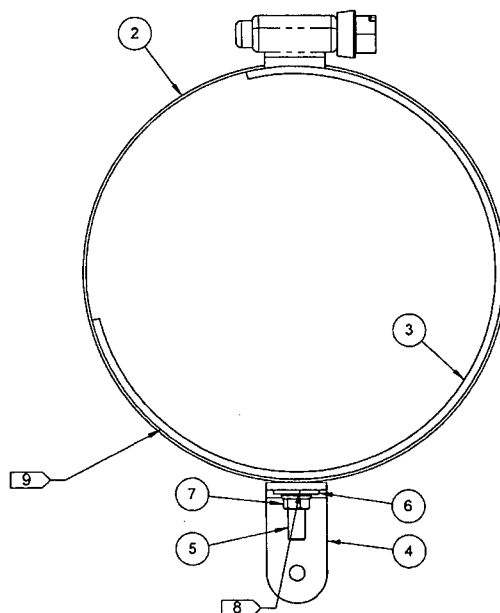
- 1) MATERIAL: MADE FROM D4062-56
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) DRILL $\varnothing 0.138$ HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

PRELIMINARY ISSUE

10.01.20

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4027	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-041	VENT CLAMP ASSEMBLY	JCA-M47-2-20
2	1	D4027-1	HOSE CLAMP	
3	1	D4027-5	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT ANGLE	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



REFERENCE ONLY

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2010-05-05

D4027-041 VENT CLAMP ASSEMBLY

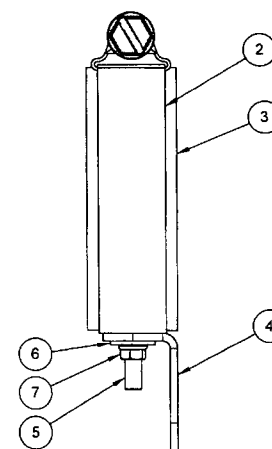
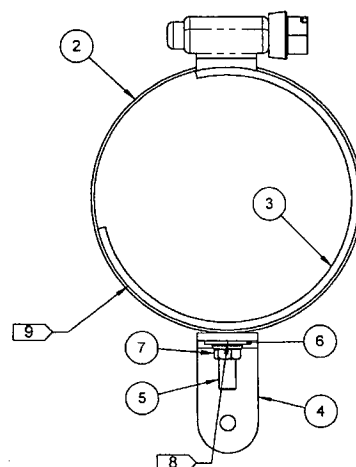
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-5 RUBBER CUSHION TO D4027-1 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

A	NEW ISSUE		10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4027	REV. A
TITLE CLAMP	SCALE NTS
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-043	VENT CLAMP ASSEMBLY	JCA-M47-2-35
2	1	D4027-3	HOSE CLAMP	
3	1	D4027-7	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT CLAMP	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



REFERENCE ONLY

D4027-043 VENT CLAMP ASSEMBLY

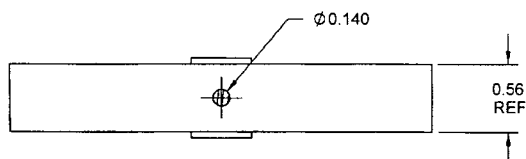
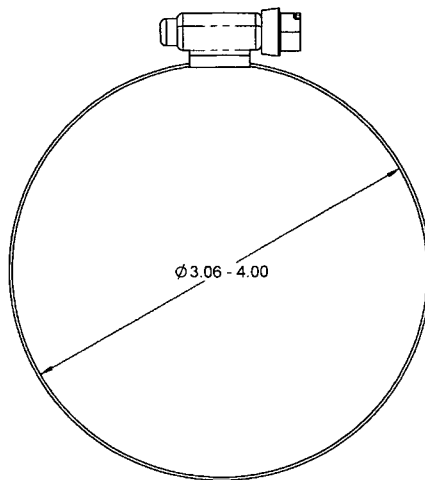
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2010-05-05
NW

NOTES:

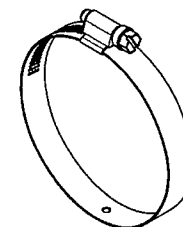
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-7 RUBBER CUSHION TO D4027-3 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4027	SHEET 2 OF 7
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-1	REF JCA-M47-2-20



D4027-1 HOSE CLAMP



REFERENCE ONLY

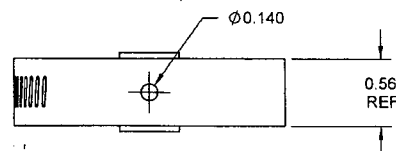
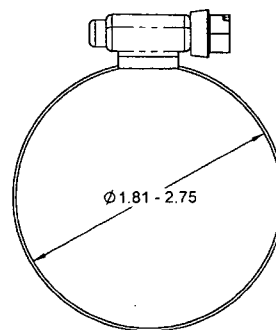
RELEASED
2010-05-15

NOTES:

- 1) MATERIAL: MADE FROM QS200M56S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-3	REF JCA-M47-2-35



D4027-3 HOSE CLAMP

REFERENCE ONLY

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2010-05-05
MD

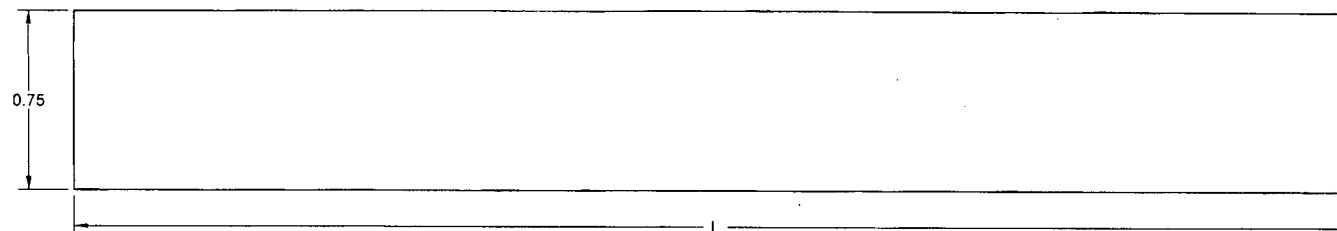
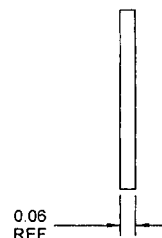
NOTES:

- 1) MATERIAL: MADE FROM QS200M36S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø 0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4027	SHEET 4 OF 7
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-5	REF JCA-M47-2-20
D4027-7	REF JCA-M47-2-35

REFERENCE ONLY



DART PART NUMBER	LENGTH "L"
D4027-5	5.30
D4027-7	8.25

D4027-X RUBBER CUSHION

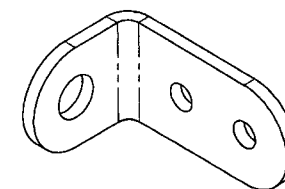
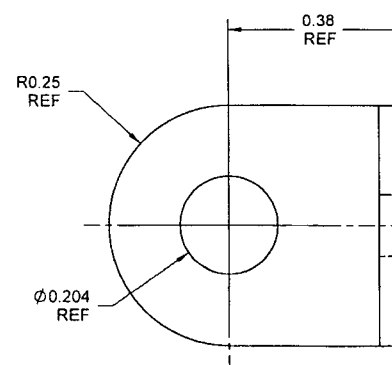
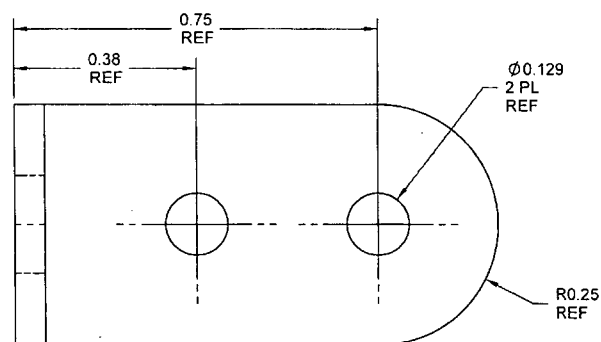
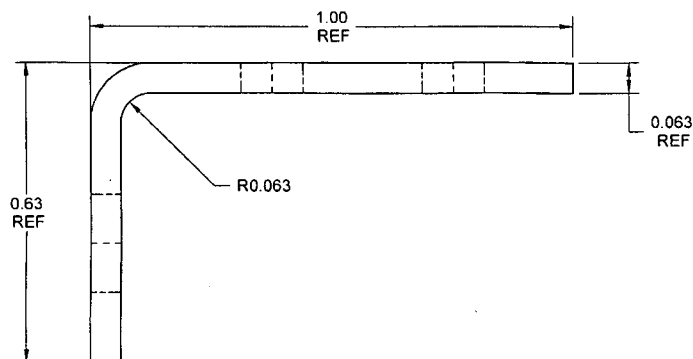
RELEASED
R 2010-05-05
MP

NOTES:

- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK
REF DART SPEC M-NEO-60-S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D4027 REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE CLAMP SCALE
DE APPR.	<i>[Signature]</i>	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-9	REF JCA-M47-2-20/-35









REFERENCE ONLY

D4027-9 BRACKET, SUPPORT ANGLE

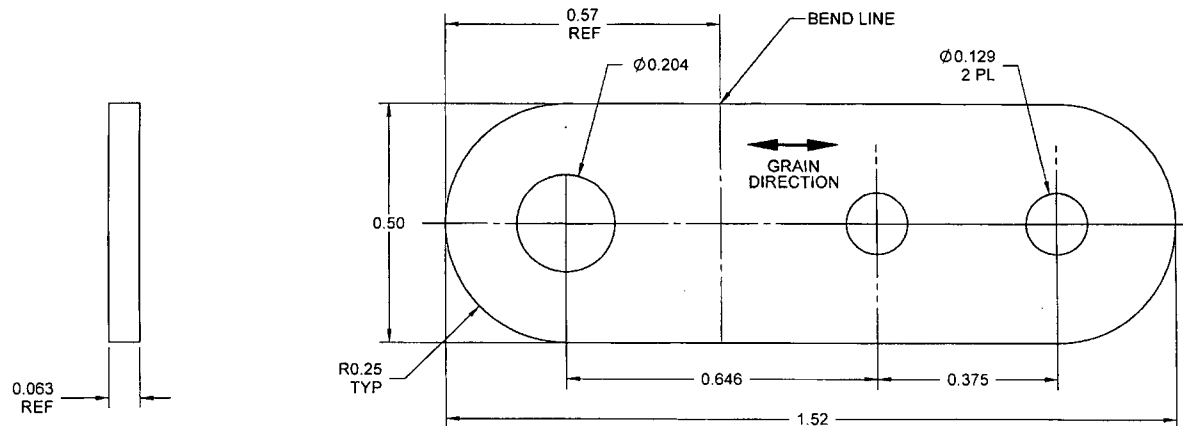
RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: MADE FROM D4027-9F OR EQUIVALENT TO AN743-C13
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4027	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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REFERENCE ONLY



D4027-9F FLAT PATTERN

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 THICK
PER AMS5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4027	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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